

Date: Wednesday, 26/11/2008 12:46:25 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 43763	Part Number	: D32045
Estimate Number	: 10494	Drawing Number	: D3204 REV. A1
P.O. Number	:	Project Number	: N/A
This Issue	: 26/11/2008	Type	: MACHINED PARTS
Prsht Rev.	: NC	Drawing Revision	: A1
First Issue	: / /	Material	:
Previous Run	: 43616	Due Date	: 05/11/2008
Written By	:	Qty:	4
Checked & Approved By	: <u>JL 08.11.26</u>	Um:	Each
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25	
		Comment: Qty.: 0.3059 f(s)/Unit Total : 1.2235 f(s) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250)	Batch: <u>M103755</u> <u>J.L 08/11/30</u>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)	<u>J.L 08/11/30</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 <u>10</u>
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA344 and Dwg D3204 2- Deburr Identify as D3204-5	<u>H.A 08/12/02</u> <u>PTD</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 <u>10</u>
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>H.A 08/12/02</u>
5.0	QC8	SECOND CHECK	 <u>H</u> <u>JULY 08.12.03</u> <u>10</u>
		Comment: SECOND CHECK	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3204-5 PAR #: N/A Fault Category: Prod Eng Coord. NCR: Yes No DQA: 1 Date: 08-12-04  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: 1 Date: 08/12/04

NCR: 43763		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/02	3.0	Z origin too low for jaws in folio.  R.C: Folio error.	J 081202	raised origin in folio by .020"  Scrap; replace qty 1. correct folio & attach n	J.A 08/12/02 J.A.12.03 08/12/03	J.A.12.03 08/12/03	J 081202	J 0812-02
				COPY (Reference copy) to this w.o.				

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:25 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 43763

Part Number: D32045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

welding (eric)

AS 08/12/03 (x10)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43763
Description: Arm	Part Number:	D3204-5
Inspection Dwg: D3204	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST.

## X First Article      Prototype

Measured by:	<u>J.A</u>	Audited by:	<u>Jung</u>	Prototype Approval:	N/A
Date:	<u>08/12/02</u>	Date:	<u>08.12.03</u>	Date:	N/A

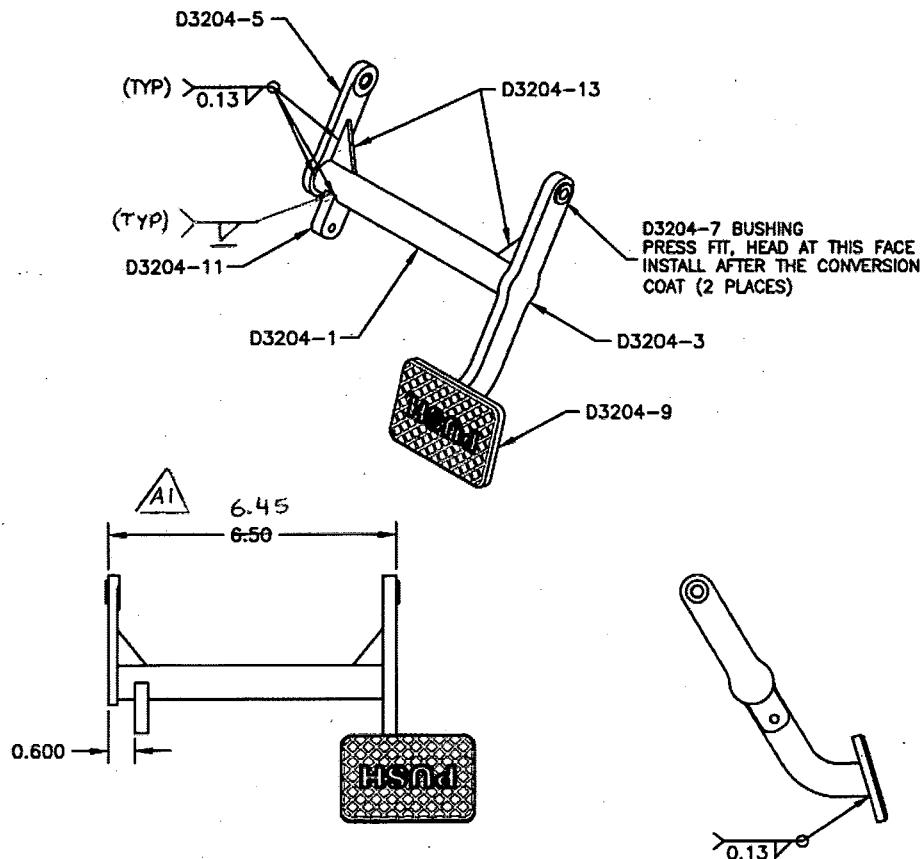
Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	06.03.21	Dwg Rev update	KJ/JLM	<i>[Signature]</i>

**DART**DRAFT COPY IS  
FOR INFORMATION ONLY

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS	

**RELEASED**  
04.04.30

A	04.01.27	NEW ISSUE
A1	05.07.15	6.45 WAS 6.50

**D3204-041 RELEASE PEDAL ASSEMBLY****NOTES**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T60.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

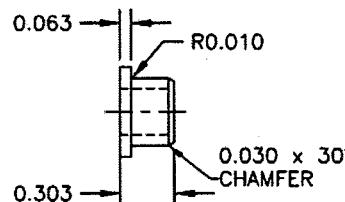
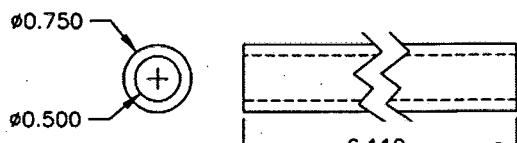
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WORK CD 01  
NO 413763



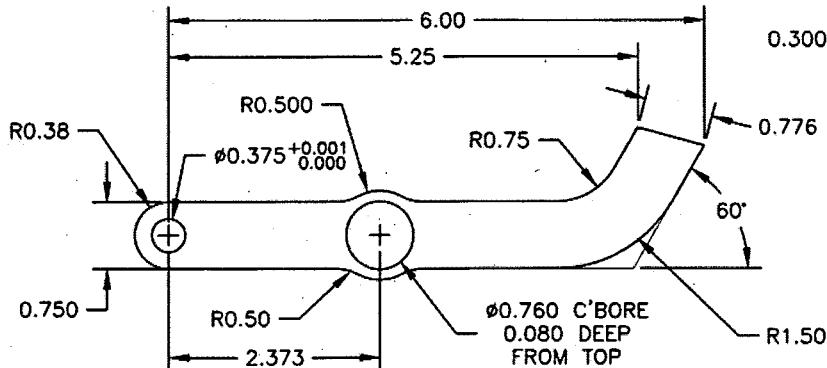
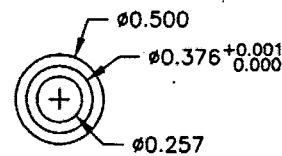
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CHECKED 	APPROVED 	DRAWING NO. D3204	REV. A	SHEET 2 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE	NTS

**RELEASED**  
01.04.05 #

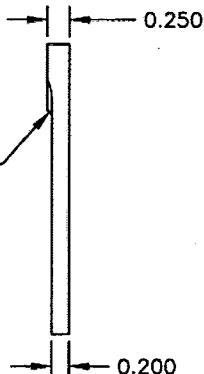
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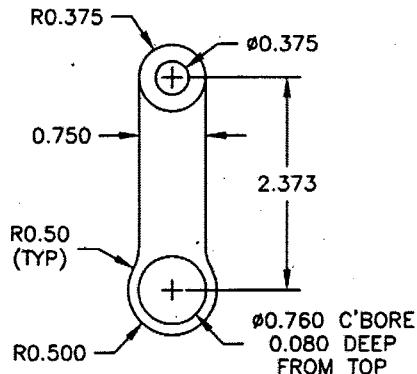
**D3204-7 BUSHING  
SCALE 1:1**



**D32D4-3 ARM**  
SCALE 1:2



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WITHOUT NOTICE  
WORK ORDER  
NO. 43763



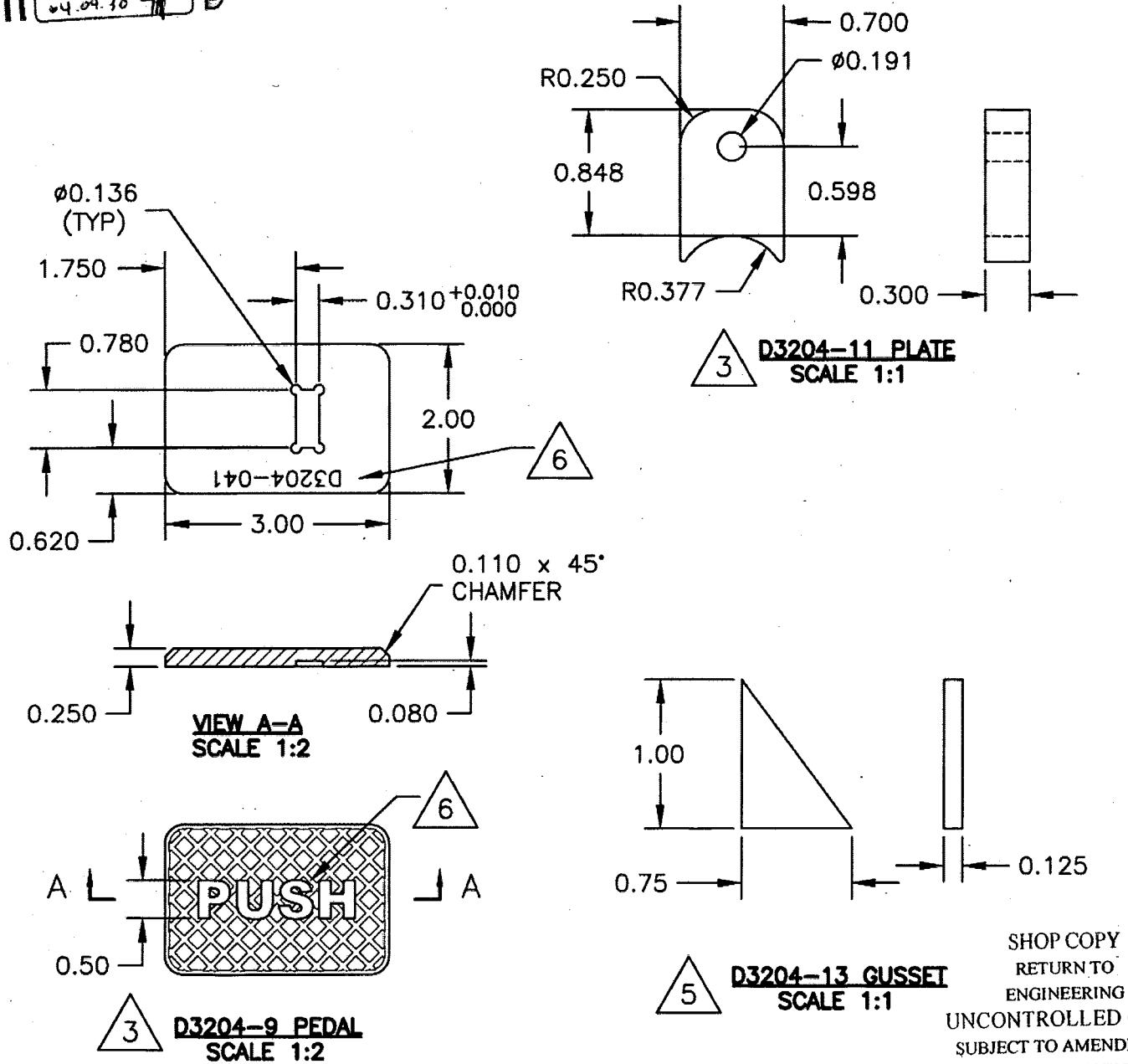
**3** D3204-5 ARM  
SCALE 1:2

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3204
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY	REV. A SHEET 3 OF 3 SCALE NTS

**RELEASED**

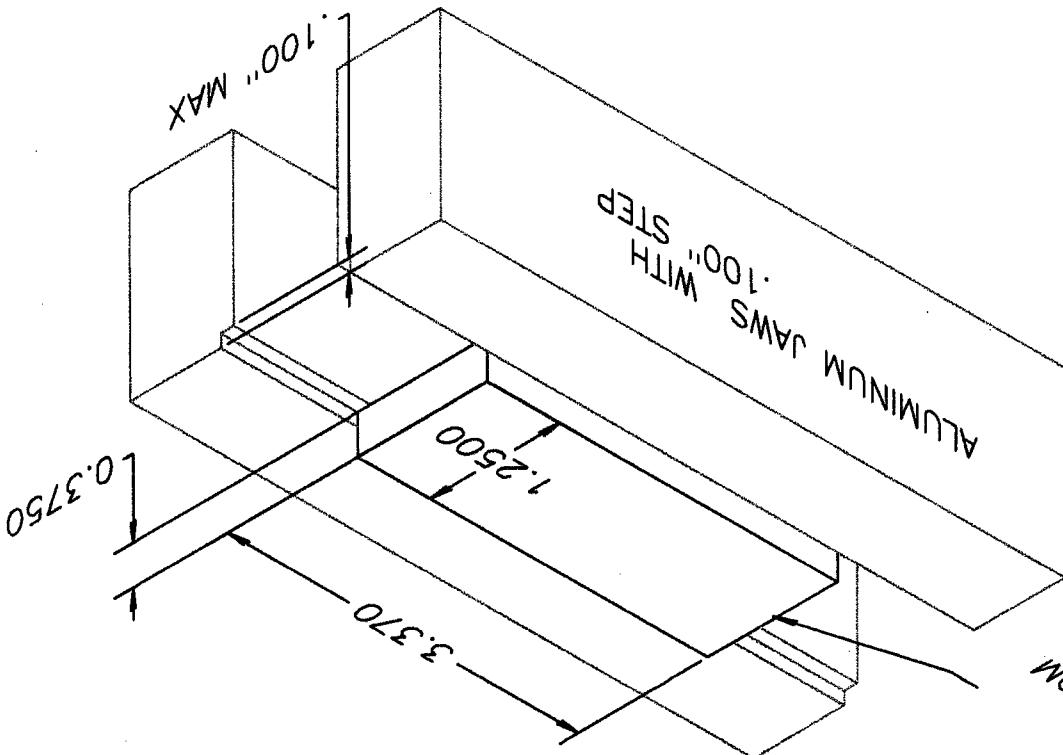
04.04.30



D3204-5 1ST OPERATION

REFERENCE ONLY

X=0.0 (CENTRE) FROM  
Y=0.0 (CENTRE) FROM  
Z=0.345" FROM BOTTOM

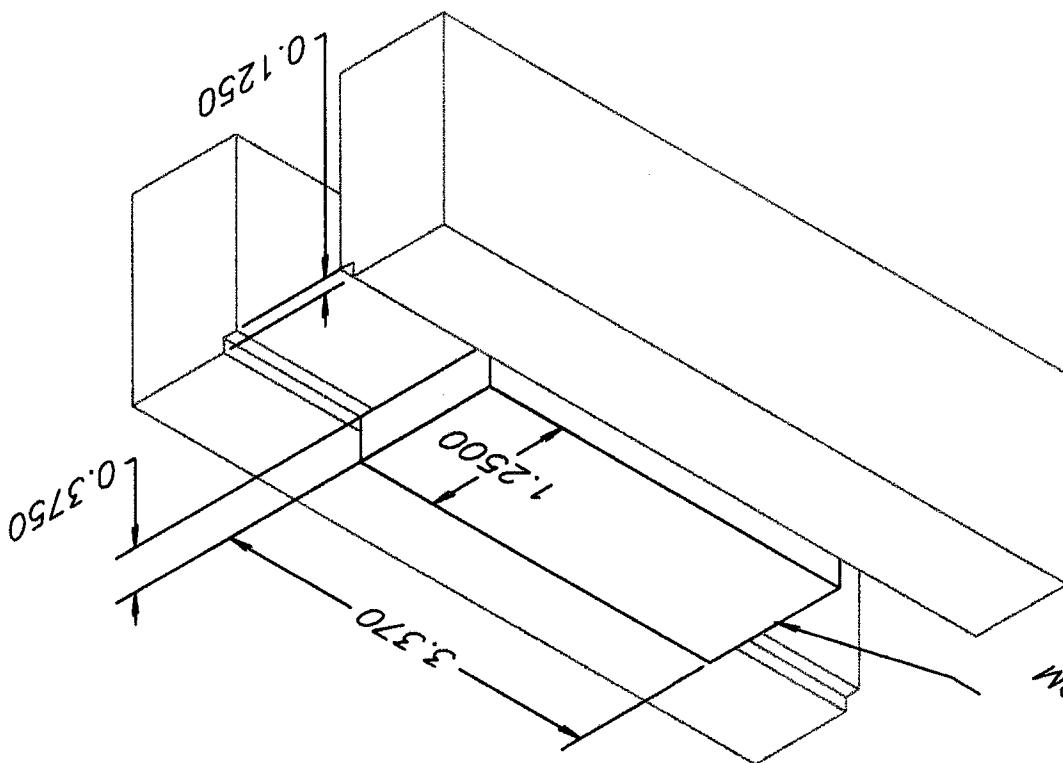


PROG #3000

D3204-5 1ST OPERATION

REFERENCE ONLY

X=0.0 (CENTRE)  
Y=.345" FROM BOTTOM  
Z=.345" FROM BOTTOM



PROG #3000